

Work Order ID 160763

Wednesday, May 03, 2017 2:21:50 PM

646.9601
B160763
REV N/C

160763

Page 1

Item ID: 646.9601 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Upper Cutter Assembly
Start Date: 5/11/2017 Start Qty: 2.00 *2* Cust Item ID:
Required Date: 5/16/2017 Req'd Qty: 2.00 *2* Customer:
Reference: (P.A.)SCHEDULED/S

Approvals: Process Plan: DAS 21 Date: MAY 04 2017 Tooling: _____ Date: _____ Run Start *NR1*
QC: 9-89 Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
646.9600	N/C								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120		0.00							
120									
Small Fab	Memo	1.92							
Small Fab	Assemble as per dwg and apply loctite 598 on all faying surfaces per note 2.								
	A/R RTV LOCTITE 598: <u>137353</u>								
	exp. date: <u>02/17</u>								
130	QC5- Inspect part completeness to step on W/O	0.00							
130									
QC	Memo	0.04							
Quality Control									

DAS
6
9-89

17/5/5

2x

17/05/16

DAS
36
9-89

2

DAS
38
9-89

MAY 16 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____		
Description Work Order Deviation				Disposition					

Root Cause			FAULT CATEGORY					
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong			
Design ☐	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions			
Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance			
Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect			
Handling/Pre ☐	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing			
Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved			
Internal Transport ☐	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing			
Tribal Knowledge ☐	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish			
LOA ☐	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread			
Substation ☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence			
Past Expiry Date ☐	☐ Manufacturing Process	OTHER : _____						
Misidentified ☐	☐ Past Due							

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Page 2

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 *140* Packaging Packaging	Identify as per dwg & Stock Location. CCF039 Memo ***IDENTIFY AS PER IAW MPP-120***	0.00 0.02							MAY 18 2017 DAS 6 9-89
150 *150* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.20							17/5/18 98

**DAS
21
9-89****MAY 18 2017**

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Picklist Print

Thursday, May 04, 2017 3:17:56 PM

Page 1

Work Order ID: 160763

160763

Parent Item: 646.9601

646 9601

Parent Item Name: Upper Cutter Assembly

Start Date: 5/11/2017

Required Date: 5/16/2017

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 12.08.13 NEW ISSUE DD VERF:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

646.9701

Manufactured

No

110

Each

3.0000

1

2

646 9701

Cutter Sub Assembly

**

MAY 05 2017

Location

Loc Qty

Loc Code

CCK007

3

157396

3

646.9811

Manufactured

No

110

Each

4.0000

1

2

646 9811

Upper Deflector

**

MAY 05 2017

Location

Loc Qty

Loc Code

cck011

4

157248

4

MS21042L08

Purchased

No

110

Each

864.0000

3

6

MS21042L 08

Nut

**

MAY 05 2017

Location

Loc Qty

Loc Code

GA

108

m135274

6

m135978

102

ST303

756

m137178

28

m137320

128

m137391

600

Picklist Print

Wednesday, May 03, 2017 2:21:50 PM

Page 2

Work Order ID: 160763

160763

Parent Item: 646.9601

646 9601

Parent Item Name: Upper Cutter Assembly

Start Date: 5/11/2017

Required Date: 5/16/2017

Start Qty: 2.00

Required Qty: 2.00

MS27039-08-19

Purchased

No

110

Each

332.0000

3

6

MS27039-08-19

MAY 05 2017

Screw

Location

Loc Qty

Loc Code

GA

30

m135948

26

m137178

4

ST277

302

m137320

102

m137361

200

NAS1149FN832P

Purchased

No

110

Each

2,358.000

6

12

NAS1149FN832P

MAY 05 2017

Washer

Location

Loc Qty

Loc Code

GA

358

M135058

208

M136182

40

M136866

110

ST263

2000

M137412

2000

12

DQA: _____ Date: _____



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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
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Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER : _____							

APICAL INDUSTRIES, INC.	ENGINEERING CHANGE NOTICE NO. 02743				SHEET 1 OF 1	
	DWG NO. 646.9600	REV: N/C	PREPARED BY S. HUFF	DATE: 01/07/10	EFFECT ON DWG ☐ INC. ☒ UNINC.	
	DWG TITLE: CUTTER ASSY					
	APPROVED BY: ENGR <i>P. Brand</i>	MFG <i>Amel Garg</i>	QC <i>Mark Lopez</i>	EFF: NEXT ORDER		
TRANSACTION CODES (TC): A-ADD C-CREATE R-REVISE D-DELETE	REASON: REVISED SCREW LENGTH.					

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 16076345
170504

3	R	601.3157	3	3	3	SCREW	MS27039-0818
			.9603	.9602	.9601		
F/N	TC	PART NUMBER	QTY		DESCRIPTION		MATERIAL/SPECIFICATION
DOCUMENTS EFFECTED: ☐ MDL ☐ INSTALL INSTRUC ☒ ICA ☐ FMS ☒ BOM							CHANGE CATEGORY ☐ MAJOR ☒ MINOR
							DER REVIEW REQUIRED ☐ YES ☒ NO

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

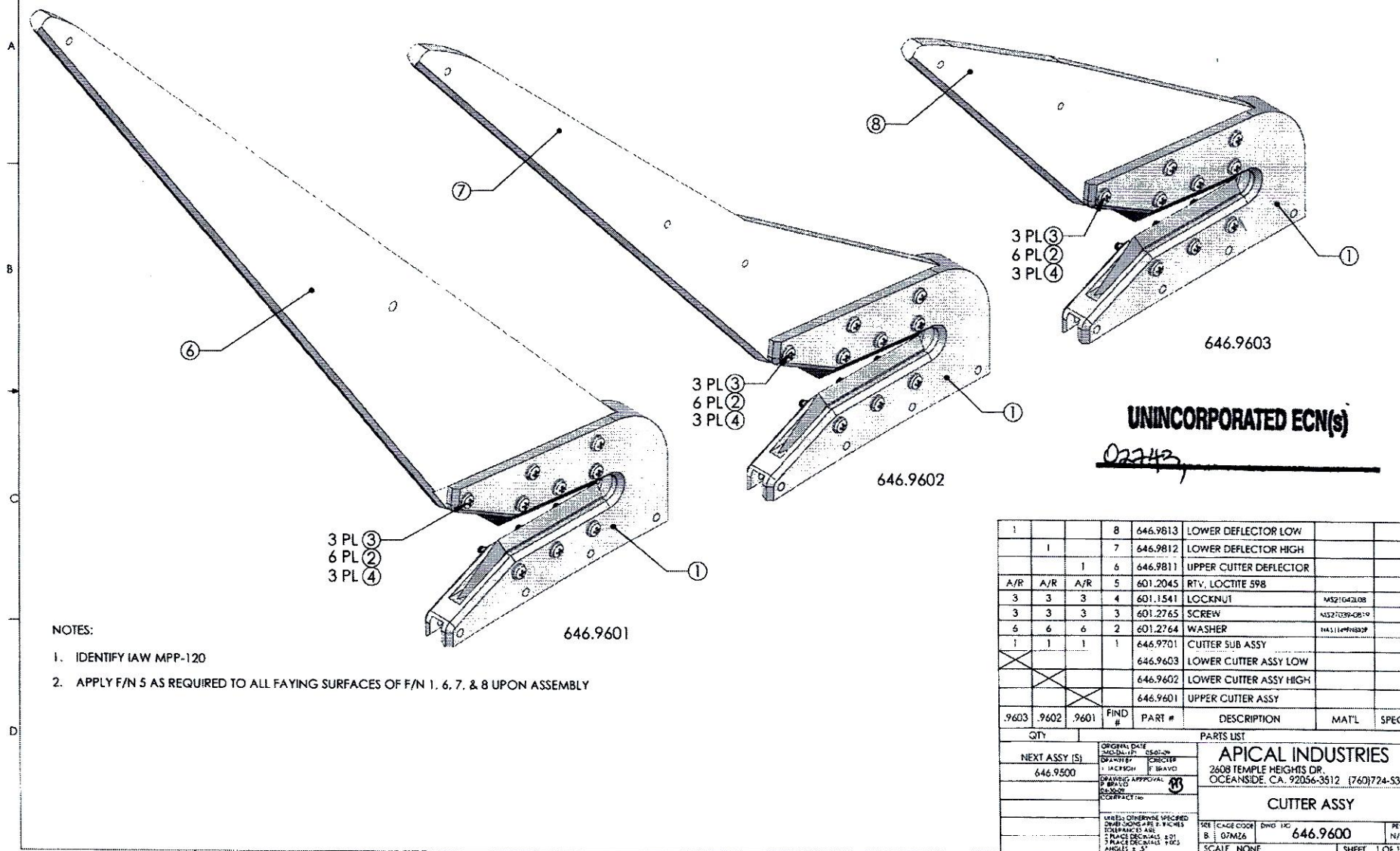
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Past Expiry Date ☐	Manufacturing Process ☐								
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REVISIONS		
REV	DESCRIPTION	DATE
1	LAST PROTOTYPE REVISION #1	11/11/07
2	FINAL RELEASE	04/30/07



DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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